Qtv:

: RADIUS BLOCK

: D2274

: N/A

: D2274 REV F-

: 15/10/2008

Date: User:

Thursday, 18/09/2008 11:12:59 AM

Julie Lecocq

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

6061-T6 Bar .750 x .125

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

S.O. No.

: 42099 : 10822

P.O. Number

This Issue

: 18/09/2008 : NC Prsht Rev.

First Issue

: 41422

Previous Run

Written By

Checked & Approved By

Comment

Type

: Est. H 00.05.18 Added inspection level 8

Additional Product

Job Number:



Seq. #: 1.0 Machine Or Operation:

M6061T6B0750X00125

Comment: Qty.:

Total: 0.0962 f(s)/Unit

6061-T6 Bar .75" x .125"

48.0900 f(s)

: MACHINED PARTS '

M103503 N104480 X 144 + 27

n 103 765 x 126

10 feet of M103503 has not been taken from computer, please enter manually from office)

*5*60 Um:

Each

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch SHEAR

2.0

3.0

SHEAR

Comment: SHEAR

Shear blanks 9.00" long +/- 0.030"

Note: 1 blank makes 9 pieces

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

Comment: SECOND CHECK

Page 1

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	Johns.	· · ·		·									
W/O:			,WC	RK ORDER CHANGES	3				<u> </u>				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief,Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _					
	R	Resolution:	Disposition	n:	QA: N/C C	closed:		Date: _					
NCR:		1	WORK ORDER NON-CONFOR					RMANCE (NCR)					
DATE	OTED	Description of NC	Corrective Action Section B			Verifi	Verification	Approval	Approval				
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector				
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NOTE: Date & initial all entries

Date: Thursday, 18/09/2008 11:12:59 AM User: Julie Lecocq **Process Sheet** 'Customer: CU-DAR001 Dart Helicopters Services Drawing Name: RADIUS BLOCK Job Number: 42099 Part Number: D2274 Job Number: Seq. #: Machine Or Operation: Description: SMALL FAB 1 6.0 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble 08/10/18 499 Deburr any rough edges after tumbling 7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL TION/W/O RELEASE Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES			** .	1	
DATE STEP		PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	jory:	_ NCR	: Yes	No DQ .	A:	Date:	
		solution:	ion: Disposition:				sed:	ed:		
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE	(NCR)		1	
		Description of NC	Corrective Action Section B				Verific	cation	Approval	Approval
DATE .	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42099
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F	· · · · · · · · · · · · · · · · · · ·	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First A	rticle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005	60.259				
0.750	+/-0.010	0.755	~			
0.375	+/-0.010	0.3745				
0.125	+/-0.010	0.126	V			
0.750	+/-0.010	0.754	~			
0.063	+/-0.010	0.063	~			
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Measured by: HA	Audited by:	Prototype Approval:	N/A
Date: 08/09/27	Date: 08/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF 🚓	SHOPPOPY

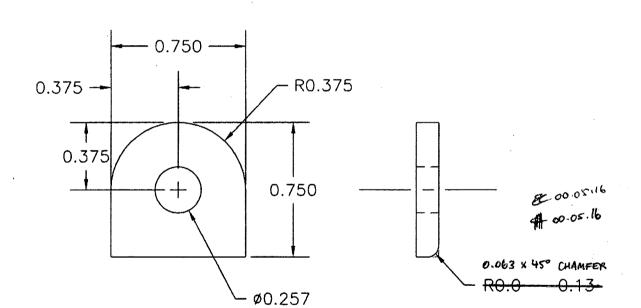
RETURN TO
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DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	NNY	APPROVED	DRAWING NO. REV. 1 D2274 SHEET 1 OF	1
DATE	· W/	1 /2	TITLE SCALI	
98.0	08.11		RADIUS BLOCK 2:	1
Α		94.09.29	NEW ISSUE	
С		95.07.12	RADIUS ENDS	
ם		97.03.24	ADD MATERIAL SPECIFICATION	
Ε		97.12.12	ADD FINISH & TOLERANCE QSI	
F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125	

RELEASED 18 KED



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK

OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SHOP COPY ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED RETURN TO

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WORK ORDER NO. 4 2019